

S101247



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2423

Job Sheet 179423



Part No: D2423

Job Qty: 336 ft

Part Name: Lug Extrusion



Part Weight: 0 lbs

Job Created: 6/19/18

Due Date: 7/16/18

Type: Stock

Note: DWG REV B1 IPP G 04.09.02 Part Number D2423-108 changed to D2423 KJ/JLM

Ship Via:

Status: Scheduled

Priority: Medium

Job Tracking No:

Created By: Chantal Lavoie

Description:

DAS

DAS 13

21 9-89

9-89

JUN 22 2018

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing - Ft	336 ft		7/16/18	0.00	0.00	Purchasing		AT 18/08/10
110	Packaging	336 pcs		7/16/18	0.00	0.00	Packaging2		AT 18/08/10
120	QC	336 pcs		7/16/18	0.00	0.00	QC6		PD 18/08/10
130	Packaging	336 pcs		7/16/18	0.00	0.00	Packaging3		AT 18/08/10
140	QC21-SA FT	336 ft		7/16/18	0.00	0.00	QC21		AT 18/08/10

Part Op 100 - Issue P/O: 40296 Manufacture as per Dwg Possible Supplier: SIGNATURE ALUMINUM

Descriptions:

JUN 22 2018

DAS

13

9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2423P	Lug Extrusion	336 ft (1 ea)	100-Purchasing - Ft	S101186

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing - Ft	D2423P	336	0	0

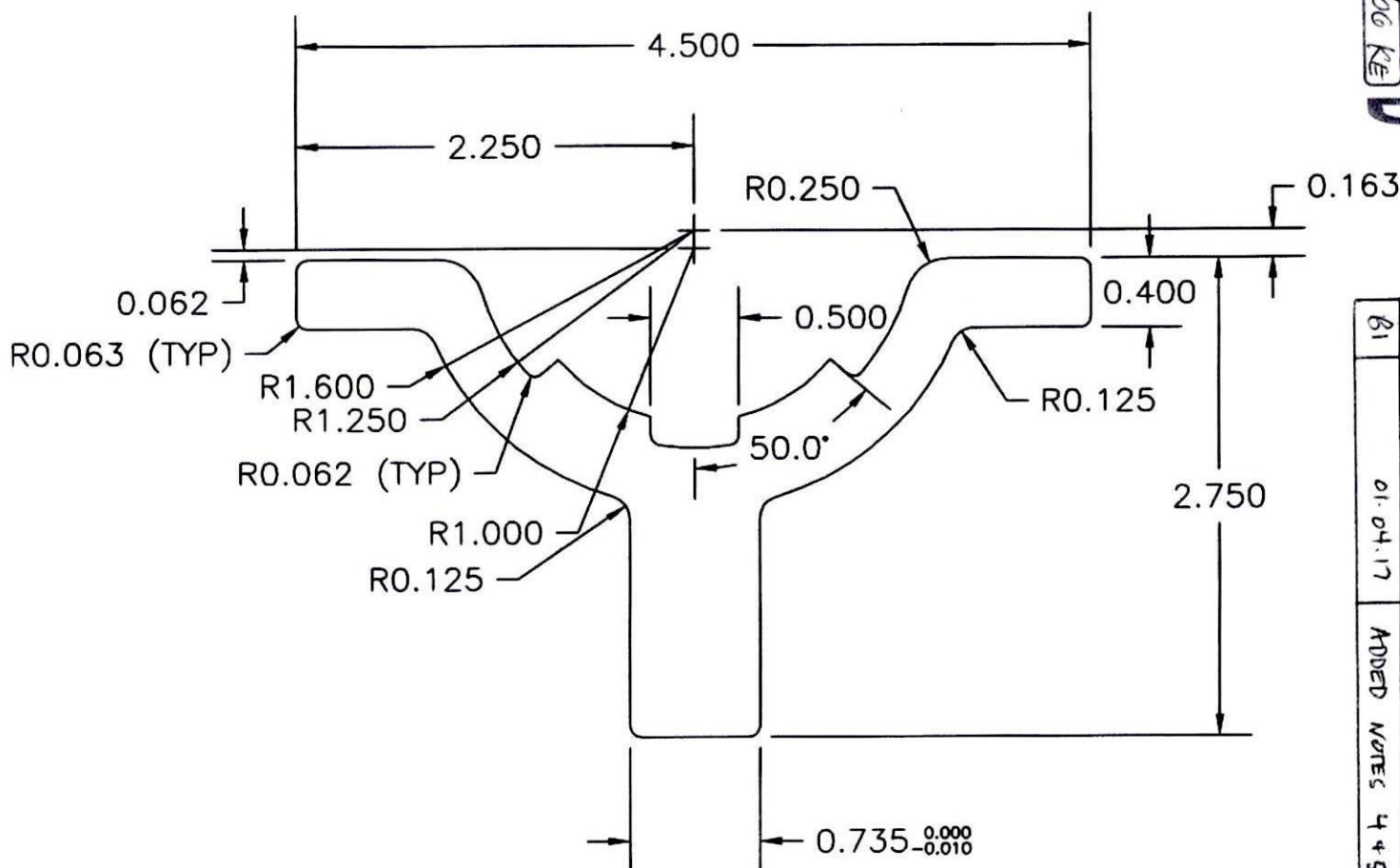
Part Specifications

Specifications could not be found.

Plex 6/19/18 8:29 AM dart.lavoie.chantal

DART**RELEASED**
98/08/06 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
KE	KE	DRAWING NO.	REV. B
98.08.04	95.05.09	D2423	SHEET 1 OF 1
DATE	DATE	TITLE	SCALE
98.08.04	95.05.09	LUG EXTRUSION	1:1
A	95.05.09	NEW ISSUE	
B	98.08.04	6061-T6 WAS 6005A.T5	
B1	01.04.17	ADDED NOTES 4 & 5	



1. MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8)
2. NOTE: ALL DIMENSIONS ARE IN INCHES
3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4. MANUFACTURED USING CARADON INDALEX DIE # MS-18866
5. PART NUMBER IS D2423-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2423-108 IS 108" LONG)



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040296**

Supplier: SIG001-VC
Signature Aluminum Canada Inc.
C/O/ T10322C
PO Box 4488, STN A
TORONTO
ON
M5W 4H1 Canada
Phone: 905-427-6550
Fax: 905-427-2246

PO No: PO040296

PO Date: 6/22/18

Due Date: 8/13/18

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal Phone: JUN 22 2018
clavoie@dartaero.com

E-MAILED

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments: QUOTE NO. 06202018-009

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	179423	D2423P		Lug Extrusion : AS PER DWG D2423 REV. B (EXTRUSION CUT AT 8 FT LONG) die # DAA-5-2 EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE OUTSIDE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES,NICKS,OR DENTS	Firmed	8/13/18	288 ft	0 ft 328 ft	288 ft	\$9.9248263/ft	\$2,858.35
2	179413	D2622-120CP		Extrusion : EXTRUDE AS PER DWG D2622-120 REV. C DIE # DAA- 897123 LENGHT 120" EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF TUBE MATERIAL MUST BE SMOOTH AND FREE FROM DEFECT SCRATCHES,NICKS,DENTS	Firmed	8/13/18	241 pcs	0 pcs	241 pcs	\$24.542323/pcs	\$5,914.70
Grand Total:										\$8,773.05	

Order Notes

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses**A005 RIGHT OF ENTRY****A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)****A012 CHEMICAL AND PHYSICAL TEST REPORTS****A016 PERSONNEL QUALIFICATION****A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)****A026 CERTIFICATION OF MATERIAL CONFORMANCE****A041 QUALITY MANAGEMENT SYSTEM****A042 DART NOTIFICATION BY SUPPLIER****A043 RETENTION OF QUALITY DOCUMENT****A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM****A049 SUPPLIER AWARENESS***Plex 6/22/18 8:24 AM dart.lavoie.chantal*



1850 Clements Road, Pickering Ontario, Canada L1W 3R8 INVOICING AND COMPANY LOCATION

Phone: (866) 587-5780 Fax: (905) 427-2207

Visit us at www.signaturealuminum.comSIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

PACKING LIST

PACKING LIST DATE / DATE DU BODEREAU	
08-09-18	
PACKING LIST NUMBER / N° DE	
038730	
SALES ORDER NUMBER / N° DE COM	
132699	

ACCT# 46024

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

ERMS / FREIGHT

PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCEREFÉREZ-VOUS À CES
NUMÉROS POUR TOUTE
CORRESPONDANCE

CUSTOMER ID / ID DU CLIENT		ORDER DATE / DE LA COM		CUSTOMER PO NUMBER / CLIENT PO Nombre		JOB / FICHIER		FIELD SALES REP / REP REGIONAL DES VENTES		CUST SERVICE REP / REP. SERVICE CLIENTELE													
46024		06/28/18		PO040296		JODEE		G.ATTENBOROU		S1S													
ITEM NO. / JUMÉRO		ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL		UNIT / UNITÉ		PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée		MFG. PART NUMBER / MFG. PARTIE NUMÉRO		ALLOY & TEMPER / ALLIAGE & TEMPER		FINISH DESCRIPTION / DESCRIPTION DE FINITION		NBR OF PKGS / NBR DE PKGS		GROSS LBS / LIVRES BRUT		NET QUANTITY / QUANTITÉ NETTE		UNIT / UNITÉ		QUANTITY DUE / Quantité en raison	
001		1,140		LB				DAA-5-2		6061 T6				1		1,232		1,215		LB			
		517		KG				D2423P		96.0000 IN						559		551		KG			
Y		37		PC						Cut (+): 0.1180		Min: -10 % Max: 10 %						41		PC			
										Cut (-): 0.0000													
														903812 / 442385		1		1,232		1,215		41 PC	

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of seller's shipping packing lists and signed and dated below by customers authorized representatives. No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping packing list were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on our website.

Page 1 of 1

1	1,232	1,215	LB
	559	551	KG
		41	PC
TOTALS			

ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

CUSTO

DATE OF DELIVERY

DRIVER

**SIGNATURE ALUMINUM CANADA**1850 CLEMENTS RD
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

Cert Date	Cert No.	Sales Order	Page
08/09/2018	5491474	132699	1
Cust PO	B/L No	Lot	Date
PO040296	038730	903812	08/09/18

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
001	DAA-5-2	8 MILL 6061 T6	D2423P
Gross Weight	1,232 LBS		
Net Qty	1,215 LBS 41 PCS 1 PKGS		
Specification		Die Desc	
AMS QQA 200/8 + ASTM B221			

Mechanical Tests:

Tensile	Yield			
MPA / KSI	MPA / KSI	% Elongation	Conductivity	HRE
332.5 / 48.2	313.1 / 45.4	14.6	N/A	95

Chemical Analysis:

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	V	Zr
0.66	0.22	0.21	0.03	0.84	0.08	0.04	0.01	0.01	0.00

*This Material is Made in Canada**This Material is RoHS Compliant*

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Gooder
Quality Manager
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

Rev A

Carrier: JODEE

Shippers No: 038730



TRL PUP2

on 08/09/18

From: SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

ISSUED AT SHIPPER'S REQUEST

EMIS A LA DEMANDE DE L'EXPEDITEUR

Received, subject to the classifications and tariffs in effect on the date of issue of this Original Bill of Lading, or received, subject to the Rules for the Carriage of Express and Non-Carload Freight Traffic and tariffs in effect on the date of issue of this Original Shipping Contract (Bill of Lading), goods described below, in apparent good order, except as noted (contents and conditions of contents of packages unknown), marked, consigned and destined as indicated below, which said Company agrees to carry to its usual place of delivery at said destination, if on its road, otherwise to deliver to another carrier on the route to said destination. It is mutually agreed, as to each carrier of all or any of said goods over all or any portion of said route to destination, and as to each party at any time interested in all or any of said goods, that every service to be performed hereunder shall be subject to all the terms and conditions (which are hereby incorporated by reference and have the same force and effect as if the same were severally fully and specifically set forth herein):

1. Railway Traffic Liability Regulations (SOR/91-488 August 14, 1991) passage of the National Transportation Act, 1987
2. of the bill of lading of the water carrier as provided in its tariffs of rules and Regulations when said goods are carried by a water carrier; or
3. of the bill of lading set forth in or prescribed by the relevant tariffs, classification, statutes and regulations pertaining to motor carrier's services when said goods are carried throughout by a motor carrier; or
4. of the bill of lading in Schedule 2 by O.C. 47-88 of January 13, 1988 when said goods originating in Quebec are to be carried by a motor carrier
5. or approved by the Board of Transport Commissioners for Canada by General Order No. T-43, set forth in the Rules for the Carriage of Express and Non-Carload Freight Traffic and also available at all express and railway agency stations and express and freight offices upon request, when said goods are carried by a rail carrier, and which are agreed to by the shipper and accepted for himself and his assigns.

Reçu, sous réserve des classifications et tarifs en vigueur à la date de livraison de ce connaissement original, ou sous réserve des règlements régissant le transport des messageries et marchandises de détail et des tarifs en vigueur à la date de livraison de ce contrat de transport (connaissement), les marchandises désignées ci-dessous, apparemment en bon état, sauf les remarques contenues aux présentes (le contenu et l'état du contenu des colis étant inconnus), marquées et consignées tel que ci-après indiqué, et que la Compagnie s'engage à transporter à destination à son lieu habituel de livraison, pourvu que telle destination soit sur son parcours, sinon à les livrer à un autre voiturier faisant route vers cette destination. Il est de plus convenu que tout voiturier transportant tout ou partie desdites marchandises sur tout ou partie du parcours, que toute personne intéressée en aucun temps à tout ou partie desdites marchandises et que tous services prévus aux présentes seront assujettis à toutes les conditions (lesquelles, par renvoi, sont intégrées aux présentes et ont la même force et le même effet que si elles étaient ici énoncées séparément, et intégralement et expressément):

1. Le Règlement sur la responsabilité à l'égard du transport ferroviaire de marchandises (DORS/91-488, 14 août 1991) adoptée en vertu de la loi de 1987 sur les transports nationaux;
2. du connaissement du transporteur maritime, conformément aux dispositions et règlements énoncés dans les tarifs s'appliquant au transport par eau; ou
3. du connaissement prescrit par les tarifs, classifications, statuts et règlements se rapportant aux services de camionnage si lesdites marchandises sont transportées par camion; ou
4. du connaissement selon l'annexe 2 du Décret 47-88 du 13 janvier 1988 si les marchandises sont expédiées de la province de Québec par camion;
5. approuvées par l'ordonnance générale No. T-43 de la Commission Canadienne des Transports pour le Canada régissant le transport des messageries et marchandises de détail et dont le texte peut être obtenu sur demande à toutes les gares de voyageurs et de messageries, ainsi qu'à tous les dépôts de marchandises si lesdites marchandises sont transportées par un voiturier du rail, conditions auxquelles l'expéditeur consent et qu'il accepte pour lui-même et ses ayants droit

Consigned To: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

S/O: 132699
Freight: Prepaid

No		LTL	Haz				
Pkgs	Description Of Articles	Cls	Mat	Net	Tare	Gross	
1	Aluminum Lineal Shapes; Item 13515-A	60		1,215 lbs 551 kgs	18 lbs 8 kgs	1,232 lbs 559 kgs	

1	TOTAL	1,215 lbs 551 kgs	18 lbs 8 kgs	1,232 lbs 559 kgs
---	-------	----------------------	-----------------	----------------------

Shipper, Per T1TONKS
SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

CANADA

CARRIER / AGENT				CONSIGNEE / CONSIGNATAIRE			
DATE	D / J	M / M	Y / A	DATE	D / J	M / M	Y / A
PER / PAR				PER / PAR			

Visit us at www.signaturealum.com

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D2423
DATE: 18/08/10

PO / BATCH NO.: P0040296/5101186

MATERIAL CERT REC'D: Yes
QUANTITY RECEIVED: 328.4
QUANTITY INSPECTED: 328.4
QUANTITY REJECTED: 0

THICKNESS ORDERED: N/A
THICKNESS RECEIVED: N/A
SHEET SIZE ORDERED: —
SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	<u>(N)</u>	
CORRECT FINISH	<u>(Y)</u>	N	
CORROSION	Y	<u>(N)</u>	
CORRECT GRAIN DIRECTION	<u>(Y)</u>	N	
CORRECT MATERIAL PER M-DRAWING	<u>(Y)</u>	N	<u>AMS QQA 200 / 8</u>
CORRECT THICKNESS	<u>(Y)</u>	N	
PHOTO REQUIRED	Y	<u>(N)</u>	
CORRECT REF # TO LINK CERT	<u>(Y)</u>	N	<u>P0040296</u>
CORRECT MATERIAL IDENTIFICATION	<u>(Y)</u>	N	
CORRECT M# ON THE MATERIAL	<u>(Y)</u>	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	<u>(N)</u>	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	<u>(N)</u>	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>AT</u>	SIGNED OFF BY: _____
DATE: <u>18/08/10</u>	DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in